

# Work Order ID 122958

Tuesday, July 29, 2014 2:26:53 PM

**\*122958\***

Page 1

Item ID: D3684-049 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Leg Ass'Y  
 Start Date: 7/29/14 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 7/29/14 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: Wm Date: 7/30/14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3684	E

100	Pick Kit	0.00							
<b>*100*</b>									
Packaging	Memo	0.00				2X	DAS 28 9-89	NOV 19 2014	
Packaging									

110	Small Fab	0.00							
<b>*110*</b>									
Small Fab	Memo	0.00				2X	DAS 28 9-89	NOV 19 2014	
Small Fab	1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684								
	2-Assemble as per Dwg D3684								

120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00				2	DAS 38 9-89		
Quality Control									

DA  
49  
9-89  
14/11/19

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<table style="width: 100%;"> <tr> <td style="width: 33%;"> <b>AGAINST DEPARTMENT/PROCESS</b>             Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </td> <td style="width: 33%;">           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </td> <td style="width: 33%;">           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </td> <td style="width: 33%;">           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </td> </tr> </table>	<b>AGAINST DEPARTMENT/PROCESS</b>  Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
<b>AGAINST DEPARTMENT/PROCESS</b>  Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 122958

\*122958\*

Page 2

Tuesday, July 29, 2014 2:26:53 PM

Item ID: D3684-049 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID: Stop \*NS2\*

Item Name: Aft Leg Ass'Y

Start Date: 7/29/14 Start Qty: 2.00 \*2\* Cust Item ID:

Required Date: 7/29/14 Req'd Qty: 2.00 \*2\* Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>St231B</u>	0.00							DAS
*130*						(2)			46
Packaging	Memo	0.00							9-89
Packaging									NOV 19 2014
140	QC21- Final Inspection - Work Order Release	0.00							14/11/2014
*140*									
QC	Memo	0.00							
Quality Control									

14-11-19

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

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# Picklist Print

Tuesday, July 29, 2014 2:26:53 PM

Page 1

Work Order ID: 122958

**\*122958\***

Parent Item: D3684-049

**\*D3684-049\***

Parent Item Name: Aft Leg Ass'Y

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM  
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP  
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC  
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified  
 By:DD IPP REV:D  
 13.01.24 PER ECN12-693 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3688-3		Manufactured	No			110	Each	21.0000	1	2			
<b>*D3688-3*</b>									<b>**</b>			DAS	NDW 7 30 2014
Stud												28	
												9-88	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST508				21					
				100388				4					
				101630				5					
				<u>105607</u>				8		2x			
				97835				4					
D3689-1		Manufactured	No			110	Each	42.0000	1	2			
<b>*D3689-1*</b>									<b>**</b>			DAS	
Sleeve												28	
												9-88	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				2					
				83358				2					
				st510				40					
				<u>105605</u>				35		2x			
				93734				5					

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

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Material									
Operator									
Offset/Setup									
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Training									
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### FAULT CATEGORY

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# Picklist Print

Tuesday, July 29, 2014 2:26:53 PM

Work Order ID: 122958

**\*122958\***

Parent Item: D3684-049

**\*D3684-049\***

Parent Item Name: Aft Leg Ass'Y

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 2.00

Required Qty: 2.00

D3691-041	Manufactured	No	110	Each	5.0000	1	2	
<b>*D3691-041*</b>								
Stud Assembly								
						<b>**</b>		DAS 28 9-89
								NOV 19 2014

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST224	5	
108014	2	
97126	1	
99689	2	

NAS509L12C	Purchased	No	110	Each	91.0000	1	2	
<b>*NAS509L12C*</b>								
Nuts								
						<b>**</b>		DAS 28 9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST270	91	
120498	1	
m128578	90	

NAS509-12C	Purchased	No	110	Each	39.0000	1	2	
<b>*NAS509-12C*</b>								
Nuts								
						<b>**</b>		DAS 28 9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST270	39	
120422	4	
121162	3	
121556	4	
121827	3	
m128199	10	
m128429	15	

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

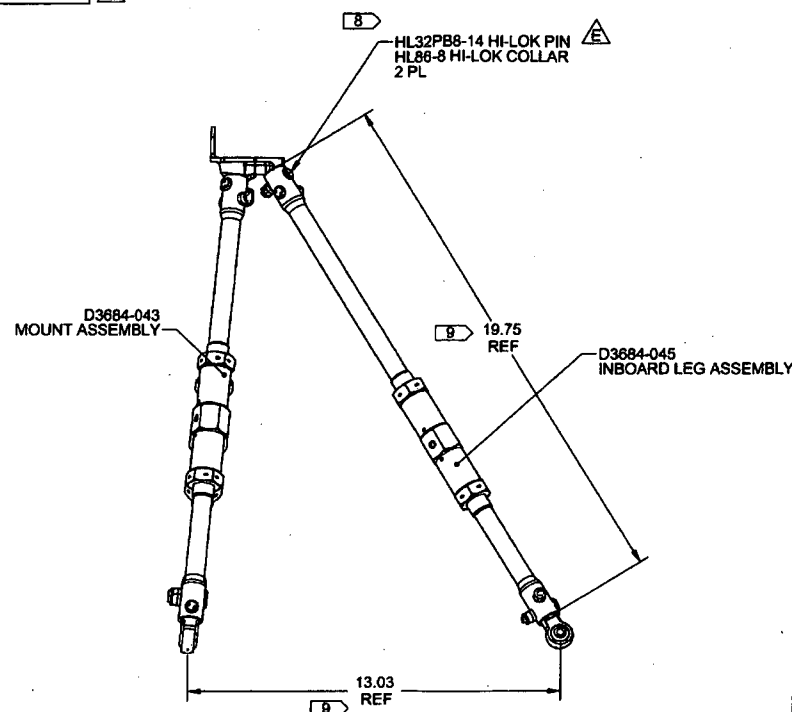
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3684-041	TRIPOD MOUNT ASSEMBLY
2	1	D3684-043	MOUNT ASSEMBLY
3	1	D3684-045	INBOARD LEG ASSEMBLY
5	2	HL32PB8-14	HI-LOK PIN
6	2	HL86-8	HI-LOK COLLAR

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

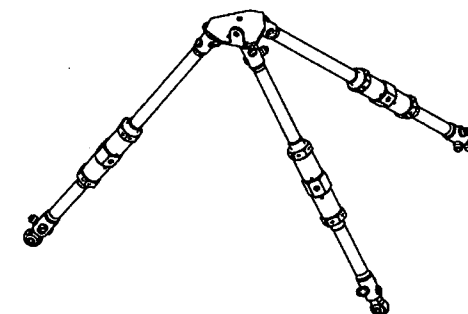
WITHOUT NOTICE  
WORK ORDER  
NO. 120958  
7/30/14 WJM



**D3684-041 TRIPOD MOUNT ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9.9 lbs
- 8) ALIGN THE PILOT HOLES IN MATING PARTS. DRILL OUT EACH HOLE USING A P/N 13-420 PILOTED DRILL (0.2314 DIA/0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER (0.247 DIA/0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY. ASSEMBLE D3684-043 WITH D3684-045 USING HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE BETWEEN MATING SURFACES.
- 9) DIMENSIONS SHOWN ARE WHEN D3688-1/3-5 & D3691-041 STUDS ARE FULLY THREADED INTO D3688-1 SLEEVES.
- 10) ASSEMBLY SHOWN FOR REF ONLY, -041 IS PACKAGED UNASSEMBLED



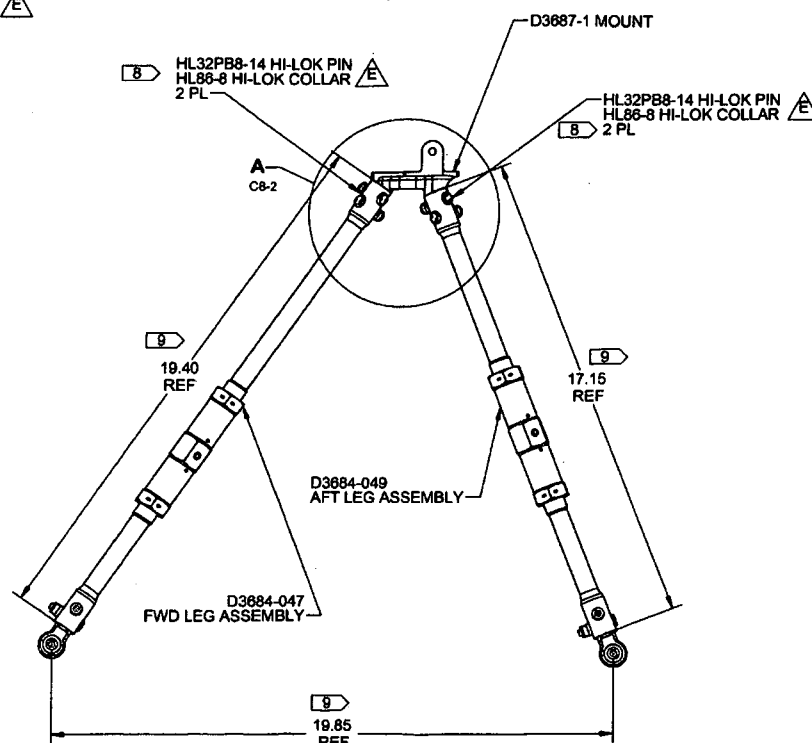
**RELEASED**  
2013-01-22

E	REMOVE AN3C-12A BOLT, D3682-1 SPACER AND MS21043-3 NUT, REPLACE WITH HL32PB8-14 HI-LOK PIN, HL86-8 HI-LOK COLLAR (ZN D4-1, ZN D4-2, ZN D6-2). REFORMAT NOTES SECTION AS PER QSI 043, CHANGE ASSEMBLY ADHESIVES LISTED IN NOTES (ZN A8-1, ZN A8-2, ZN A8-3, ZN A8-4, ZN A8-5) REF NCR12-2074.	DB	12.12.05
D	13.03 WAS 13.10 (ZN B5-1); 19.75 WAS 19.87 (ZN C4-1); 19.40 WAS 19.52 (ZN C6-2); 17.15 WAS 17.27 (ZN C4-2); 19.85 WAS 20.24 (ZN B5-2); 20.86 WAS 21.09 (ZN C5-3); 20.62 WAS 20.74 (ZN C5-4); 18.37 WAS 18.49 (ZN C6-5)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, D6-1, A8-2, D4-2, A8-3, B4-3, A8-4, B4-4, A8-5, B5-5). ASSEMBLY NOW SHOWN FOR REF ONLY (ZN A8-1, A4-1)	RF	08.12.15
B	19.52 WAS 19.50 (ZN C6-2); 9.20 WAS 9.70 (ZN C8-2); 20.74 WAS 21.24 (ZN C4-1); 6.95 WAS 6.88 (ZN D5-5). MODIFIED PER PROTOTYPE INSTALLATION; REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	JLM	<b>D3684</b>	SHEET 1 OF 5
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	<b>TRIPOD MOUNT ASSY</b>	NTS
DATE	12.12.05	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	4	HL32PB8-14	HI-LOK PIN
6	4	HL86-8	HI-LOK COLLAR

DETAIL A  
SCALE 2X  
C6-2

ORIENT HI-LOK PINS AS SHOWN  
(INSERT PIN FROM THIS SIDE)  
TO ENSURE CLEARANCE FOR  
ENGINE THROTTLE LINKAGE



**D3684-043 MOUNT ASSEMBLY**

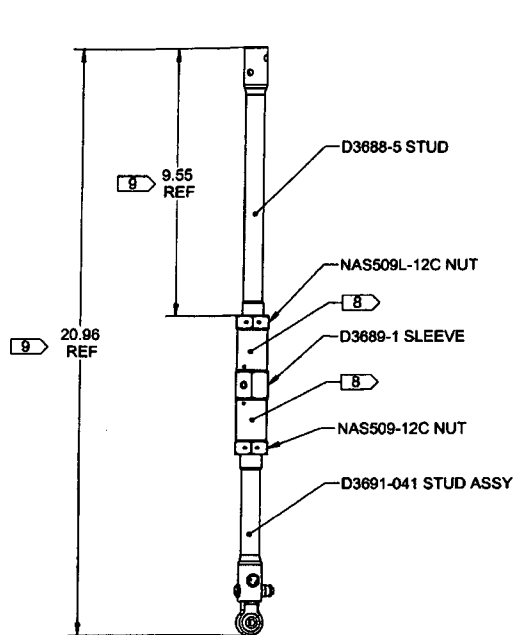
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 PER DART QSI 044 6.1 ( FINE POINT PAINT MARKER )
- 7) WEIGHT: 6.6 lbs
- 8) ALIGN THE PILOT HOLES IN MATING PARTS. DRILL OUT EACH HOLE USING A P/N 13-420 PILOTED DRILL (0.2314 DIA./0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER ( 0.247 DIA./0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY. ASSEMBLE D3684-047/049 WITH D3687-1 USING HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE BETWEEN MATING SURFACES.
- 9) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	JLM	<b>D3684</b>	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>TRIPOD MOUNT ASSY</b>	NTS
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**RELEASED**  
2013-01-22  
*[Signature]*

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-041	STUD ASSY
5	1	NAS509L-12C	NUT
6	1	NAS509-12C	NUT



**D3684-045 INBOARD LEG ASSEMBLY**

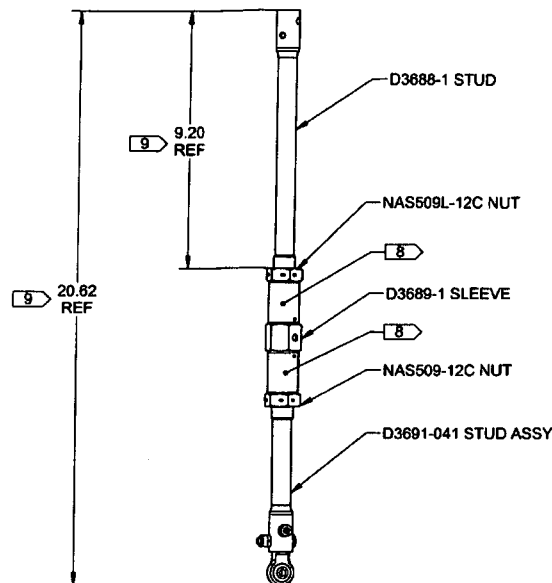
**RELEASED**  
2013-01-22  
*md*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 PER DART QSI 044 6.1 ( FINE POINT PAINT MARKER )
- 7) WEIGHT: 3.1 lbs
- 8) USE TECTYL 502C CLASS I, MIL-PRF-18173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 9) DIMENSION SHOWN IS WHEN D3688-5 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE

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MFG. APPR.	JLM	<b>D3684</b>	SHEET 3 OF 5
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-041	STUD ASSY
5	1	NAS509L-12C	NUT
6	1	NAS509-12C	NUT




**D3684-047 FWD LEG ASSEMBLY**

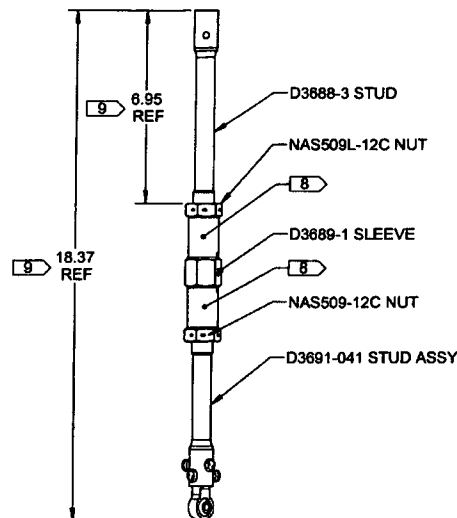
**RELEASED**  
2013-01-22

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.08 lbs
- 8) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 9) DIMENSION SHOWN IS WHEN D3688-1 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE

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MFG. APPR.	JLM	<b>D3684</b>	SHEET 4 OF 5
APPROVED		TITLE	SCALE
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ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-041	STUD ASSY
5	1	NAS509L-12C	NUT
6	1	NAS509-12C	NUT



**D3684-049 AFT LEG ASSEMBLY**

RELEASED  
2013-07-22

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.85 lbs
- 8) USE TECTYL 502C CLASS 1, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 9) DIMENSION SHOWN IS WHEN D3688-3 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
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CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	JLM	<b>D3684</b>	SHEET 5 OF 5
APPROVED	AMP	TITLE	SCALE
DE APPR.		<b>TRIPOD MOUNT ASSY</b>	NTS
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